

SPLIT

split
SP 07/10/11Date: Monday, 9/10/2007 1:19:09 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 34478 2
 Estimate Number : 12811
 P.O. Number : N/A
 This Issue : 9/10/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL / MED FAB
 Previous Run : 34260
 Written By :
 Checked & Approved By : 07.09.10
 Comment : Est Rev: A New Issue 07-03.26 ec

Drawing Name : BRACKET

Part Number : D35921
 Drawing Number : D3592 REV.B
 Project Number : N/A
 Drawing Revision : B
 Material : N/A
 Due Date : 9/17/2007

Qty: 48 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S125 6061-T6 .125 Sheet



Comment: Qty.: 0.1460 sf(s)/Unit Total : 7.0056 sf(s)

6061-T6 .125 Sheet

Batch: M104420 1307-10-11

Grain must be Along 4.63

GAIN AT 45°, SEE DWG

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3592

Dwg Rev: B 1307-10-11

Prog Rev: B

2-Deburr if necessary 1307-10-11

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

En 07/10/11

x56 counter

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bend 3-5 only

Form as per Dwg D3592 using DT8949

PTO
last page

07/10/11 (2)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 34478

Part Number: D35921

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/10/11 (X2)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ut*

11 07-10-11 (2)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2 07/10/12

Job Completion



u 07-10-12

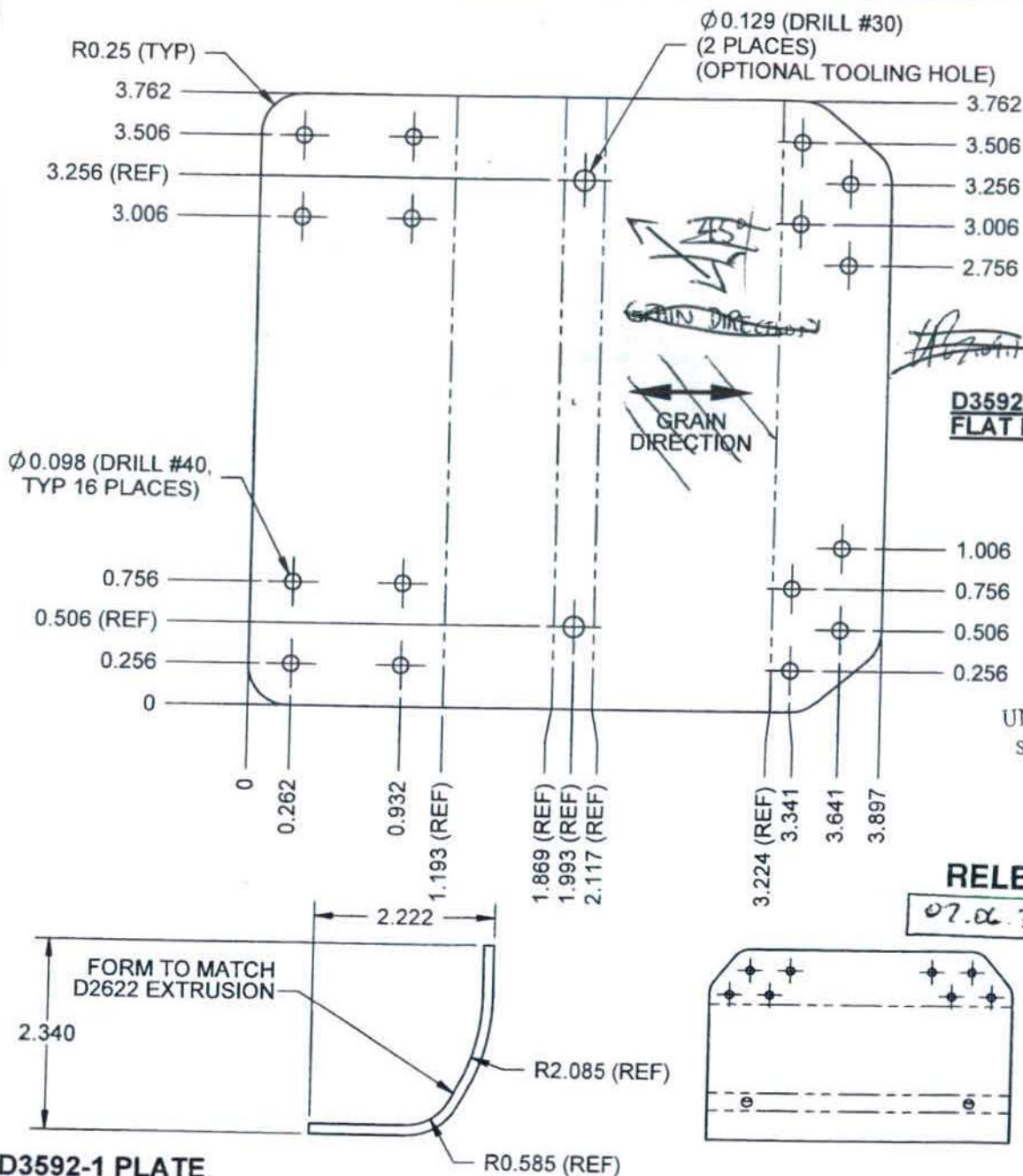
POSITIVE RECALL

EFFECTIVE *07.09.10* AUTH *CP*

RELEASED *07.10.09* DATE *LN*



DESIGN 9P	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 9P	APPROVED H	DRAWING NO. D3592	REV. E SHEET 1 OF 1
DATE 07.05.31	TITLE PLATE SCALE 1:1		
A	07.01.15	NEW ISSUE	
B	07.05.31	TOOLING HOLES ADDED	



**D3592-1F
FLAT PATTERN**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **34478**

RELEASED

07.05.31

**BEND DETAIL
SCALE 1:2**

D3592-1 PLATE

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.125" THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.125)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 MAX

COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD		Work Order:	34478
Description: BRACKET		Part Number:	D3592-1
Inspection Dwg: 3592	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+ .004 - .001	.130	X			
Ø .098	+ .005 - .001	.099	X			
.256	+/- .010	.256	X			
.506	+/- .010	.506	X			
.756	+/- .010	.756	X			
3.006	+/- .010	3.006	X			
3.256	+/- .010	3.256	X			
3.506	+/- .010	3.506	X			
3.762	+/- .010	3.762	X			
2.756	+/- .010	2.756	X			
1.006	+/- .010	1.006	X			
.262	+/- .010	.262	X			
.932	+/- .010	.932	X			
1.193	+/- .010	1.193	X			
R.25 1.869	+/- .030	.25	X			
1.943	+/- .010	1.943	X			
2.117						
3.341	+/- .010	3.341	X			
3.641	+/- .010	3.641	X			
3.891	+/- .010	3.900	X			
.125	+/- .010	.122	X			

Measured by: LB	Audited by: E	Prototype Approval:
Date: 07-10-11	Date: 07/10/11	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/06/11	5	Spice w/o 8	Sp 07/06/11	2				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

